

Work Order ID 75242

75242

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October-19-11 1:28:58 PM

Item ID: D2805-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stop
 Start Date: 19/10/2011 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2805	Rev B								

100 BAND SAW 0.00
100
 Bandsaw Memo 0.00 OK 11/11/08 16 0
 Jeaspa Bandsaw Cut Bar: 3.150" Long +0.010/-0.030"

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 HAAS 1 Memo 0.00 FK- 11/11/09 16 0
 HAAS CNC vertical machine #1 1- Machine as per Folio FA104 and Dwg D28052- Tumble and
 Deburr/Identify as D2805-1

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.00 FK- 11/11/09. 16 0
 Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	11/11/10		16	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							16x0 m 11/11/10
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				16	BR	11-11-10	

Dart Aerospace Ltd

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11/11/10

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 75242

75242

Parent Item: D2805-1

D2805-1

Parent Item Name: Stop

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: B00.11.14 Revised Finishing step to Acid etch and AlodineEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	25.4000	0.2625	4.421053			

M6061T6B1 500X01 500

6061-T6 Bar 1.50 x 1.50

Location

Loc Qty

Loc Code

MAT010

25.4

107432

1.4

118400

12

119231

12

4.43

on 11/11/08

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	75242
Description: Stop		Part Number:	D2805-1
Inspection Dwg: D2805	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.973	✓		FK-04	Vern.
0.240	+/-0.010	.240	✓		"	"
0.100 chamfer	+/-0.010	.100 x 45°	✓		"	"
1.420	+/-0.001	1.420	✓		"	"
1.125	+/-0.010	1.124	✓		"	"
0.250	+0.005/-0.000	.250	✓		"	"
0.250	+/-0.010	.250	✓		"	"
1.500	+/-0.010	1.499	✓		"	"
1.000	+/-0.010	.999	✓		"	"
0.875	+0.001/-0.000	.8753	✓		FK-01	Mic.
Ø0.191	+0.005/-0.000	.195	✓		FK-04	Vern.
2.689	+/-0.010	2.688	✓		"	"

Measured by:	FK.	Audited by:	DA	Preliminary Approval:	
Date:	11/11/09	Date:	11/11/10	Date:	

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	
C	10.06.04	0.438 dimension removed	KJ	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

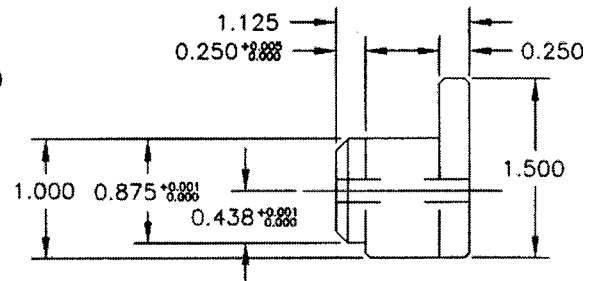
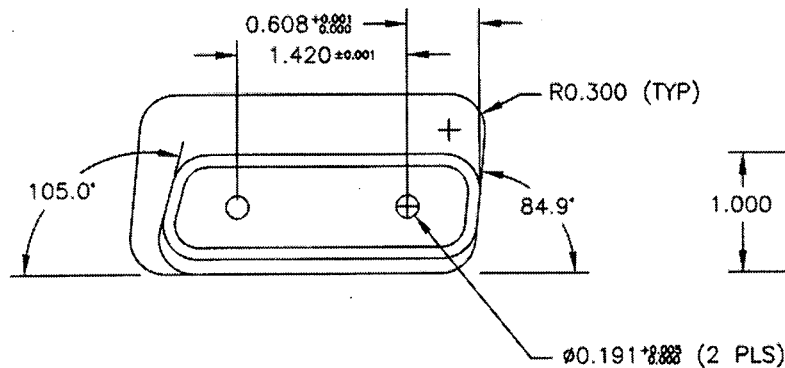
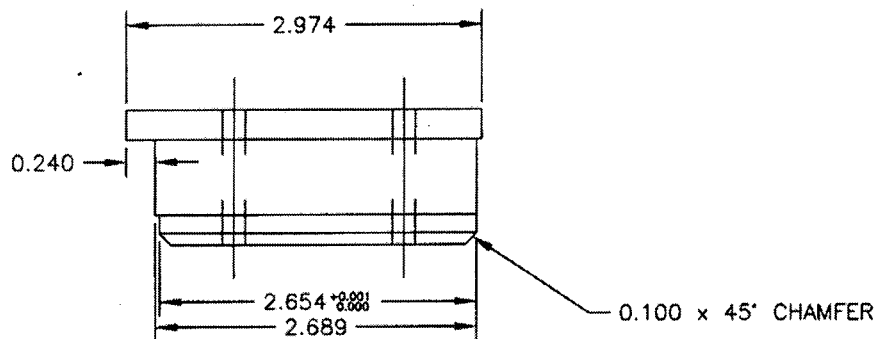
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75242 MCLJ
11/10/19

D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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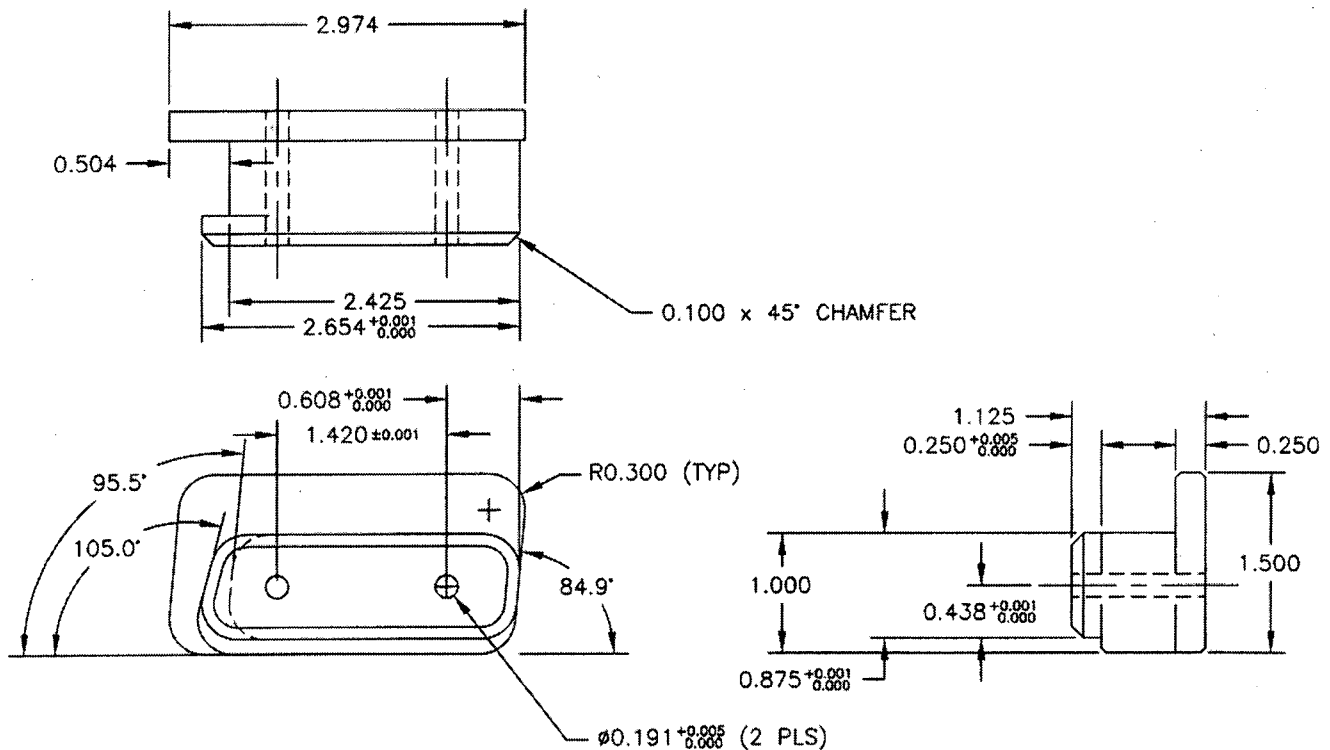
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

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BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
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